



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D5522-1
Job Sheet 173821



Part No: D5522-1

Job Qty: 10 ea

Part Name: Oil Drain Valve Mount



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D5522 REV:C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/10/18	3/10/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	10 pcs	3/10/18	3/10/18	0.00	1.00	Bandsaw1		
110	CNC Vertical Machining	10 pcs	3/10/18	3/10/18	0.00	5.00	HAAS 5 Axis		
120	QC	10 pcs	3/10/18	3/10/18	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs	3/10/18	3/10/18	0.00	0.00	QC8 Machining-4		
140	Small Fab	10 pcs	3/12/18	3/12/18	0.00	1.00	Small Fab-5		
150	QC	10 pcs	3/12/18	3/12/18	0.00	0.00	QC5		
160	Packaging	10 pcs	3/12/18	3/12/18	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea	3/12/18	3/12/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks at 3.63"

Descriptions: 110 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS

150 - ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE***

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.500X3.500	303 Bar 1.500" X 3.500"	3 ft (.3 ea)	90-Start up Operation	5077 413

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.500X3.500	3	6	0

Part Specifications

Specifications could not be found.

Plex 3/7/18 1:18 PM Dart.Gagnon.Michelle

DART
AEROSPACE

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Container No: S079384



Part: D5522-1

Job No: 173821

Serial No/Batch: S079384

Revision: C

Inspector:

Instructions:

Date: 06/08/18

DART AEROSPACE LTD		Work Order: 173 821
Description: Oil Drain Valve Mount		Part Number: DSS22-1
Inspection Dwg: DSS22 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/- .030	3.450	✓		SLIO	VerN
2.35	+/- .030	2.350	✓			
3.35	+/- .030	3.345	✓			
2.00	+/- .030	1.996	✓			
1.25	+/- .030	1.246	✓			
R.63	+/- .030	.630	✓			
.80	+/- .030	.800	✓		Rad gauge	
R.13	+/- .030	.130	✓		SLIO	VerN
R.50	+/- .030	.500	✓		Rad gauge	
R.50	+/- .030	.500	✓			
φ.390	+ .006/- .001	.395	✓		SLIO	VerN
.63	+/- .030	.630	✓		"	
7/16-20UNF	—	7/16-20	✓		Thread gauge	
φ.515	+ .008/- .001	.518	✓		SLIO	VerN
9/16-18UNF	—	9/16-18	✓		Thread gauge	
R.125	+/- .010	.125	✓		Rad gauge	
R.156	+/- .010	.156	✓		"	
1.260	+/- .010	1.258	✓		SLIO	VerN
.630	+/- .010	.628	✓			
.25	+/- .030	.250	✓			
.39	+/- .030	.387	✓			
R.13	+/- .030	.130	✓		Rad gauge	
.100	+/- .010	.100	✓		SLIO	VerN
φ.718	+ .008/- .001	.722	✓			
1.16	+/- .030	1.158	✓			
1/2 NPT	—	1/2 NPT	✓		Thread gauge	
.80	+/- .030	.800	✓		SLIO	VerN
.03 X 45°	+/- .030 X .5°	.032	✓			
1.10	+/- .030	1.099	✓			
.550	+/- .010	.547	✓			
1.18	+/- .030	1.176	✓			
R.13	+/- .030	.125	✓		Rad gauge	

Measured by: 20 9-89	Checked by:	QC Inspector:
Date: 18-06-04	Date:	Date:

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

